

Date Thursday, 16/08/2007 10:23:01 AM
User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
Job Number : 33995
Estimate Number : 11019
P.C. Number : *N/A* Part Number : D27313
This Issue : 16/08/2007 S.O. No. : *N/A* Drawing Number : D2731 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : B
Previous Run : 30994 Material : *N/A*
Written By : Due Date : 15/09/2007 Qty: 50 Um: Each
Checked & Approved By :
Comment : Est:D 0005.19 Added inspect level 8, removed P/O for powder coating EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 3.5858 f(s)

Lug Extrusion D2423

Batch: *B33310 C207/08/20*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut D2423 Extrusion: 0.82" Long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2731-3

Check for crack while loading into the machine

Tumble Deburr any rough edges after tumbling

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK Inspect level 5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 10 Date: 21/09/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:23:01 AM
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Drawing Name: LUG

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



50x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H

07/09/06

7.0

POWDER COATING

POWDER COATING



50

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068

BR

07-09-06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



50x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-H

07/09/06

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/09/11

50

10.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

07/09/11

Job Completion



07-09-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

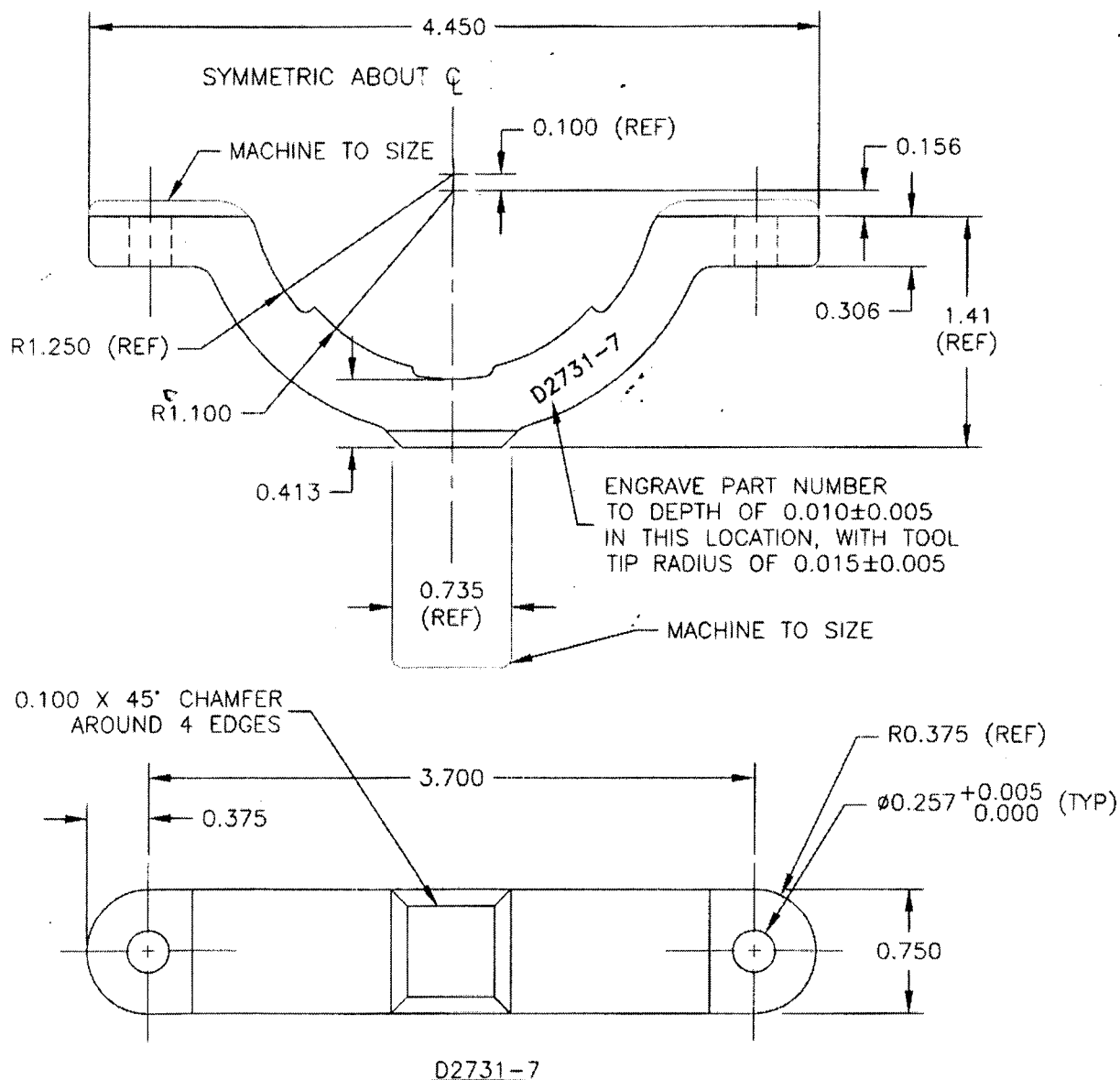
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 4 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

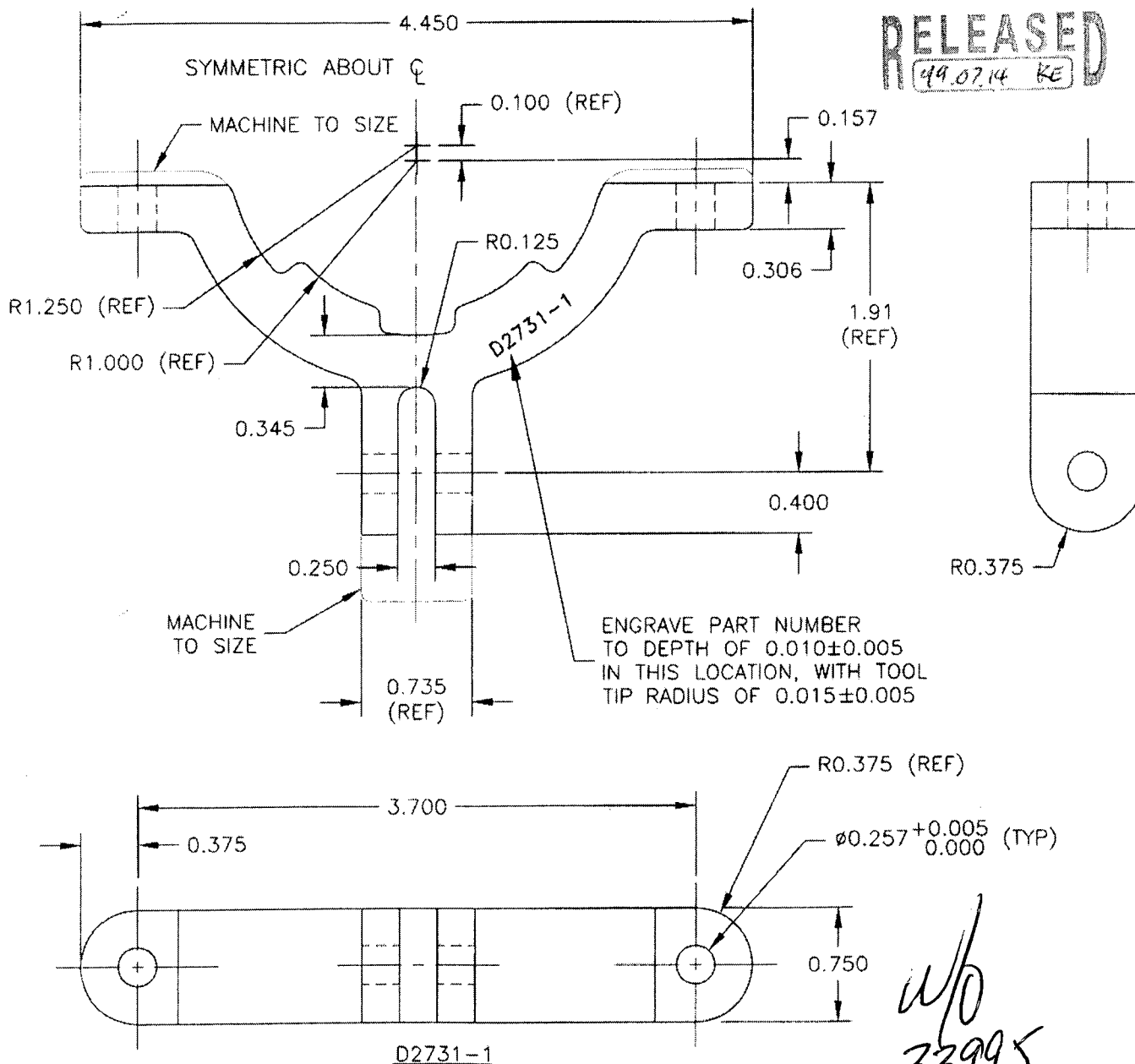
RELEASED
99.07.14 *KE*



MAKE FROM EXTRUSION D2423
 BREAK ALL EDGES 0.000-0.015
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. B SHEET 1 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1
A	98.05.13	NEW ISSUE	
B	99.07.06	REVISED DIMENSIONS	

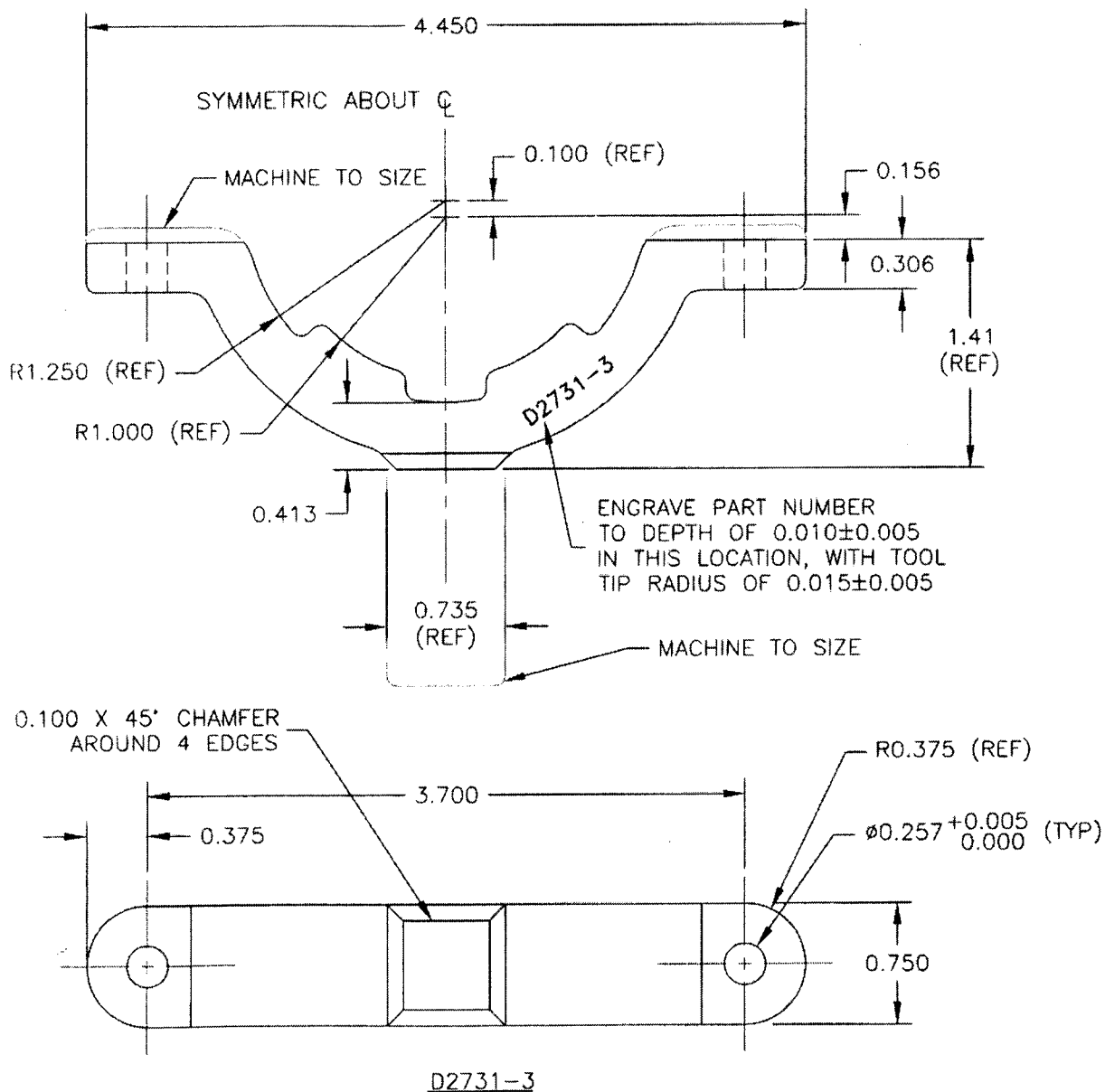


MAKE FROM EXTRUSION D2423
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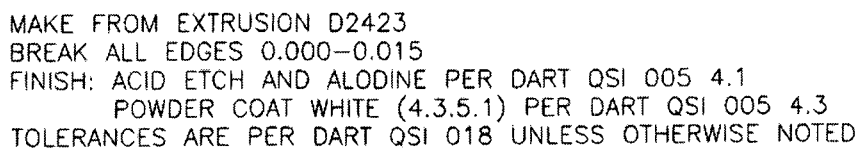
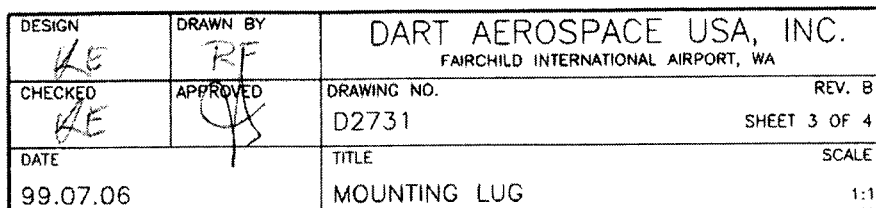


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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2731	REV. 8 SHEET 2 OF 4
DATE 99.07.06		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.07.14 KE



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
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POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3414-3	Lug Assembly MATERIAL: supplied by DART	4404
50	D2731-3	Lug MATERIAL: supplied by DART D2423 B33310	4404

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, August 31, 2007